

Work Order ID 69993

Wednesday, May 25, 2011 10:52:02 AM



Page 1

Item ID: D4382-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angled Bearpaw Clamp

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4382

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 080

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B11-5-30

[Signature]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

0.00 8 w/65131

(4)

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

0.00 SB 1166607

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

0.00 8 w/66607

(x4)

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Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 453

0.00



Packaging

Memo

0.00

Packaging

11/6/8 SP 4

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/9 MF 11-06-08

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 10:52:08 AM

Page 1

Work Order ID: 69993



Parent Item: D4382-1



Parent Item Name: Angled Bearpaw Clamp

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S14GA

Purchased

No

100

sf

27.1000

0.05513

0.232126

12.5



131-5-30

304SS sheet .080

Location

Loc Qty

Loc Code

④

MAT020

27.1

113295

27.1

113295

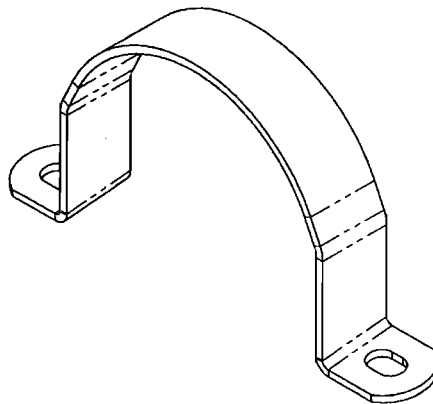
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D4382-1 ANGLED BEARPAW CLAMP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 69993
11-0525

RELEASED
 2011-04-21
JD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
 PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
 REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4382-1" AND B/N "BXXXXX"
 PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.13 lbs

A		NEW ISSUE		AJS	11.03.28
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED		<u>JD</u>	DRAWING NO.	REV. A	
MFG. APPR.		<u>JD</u>	D4382		SHEET 1 OF 2
APPROVED		<u>JD</u>	TITLE	SCALE	
DE APPR.		<u>JD</u>	ANGLED BEARPAW CLAMP	NTS	
DATE		11.03.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

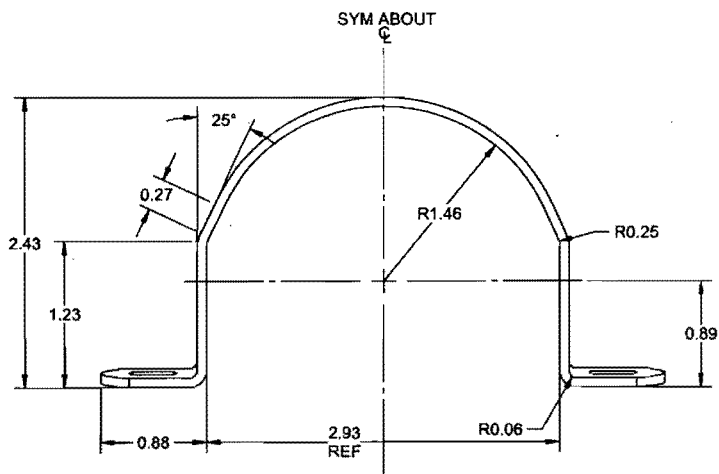
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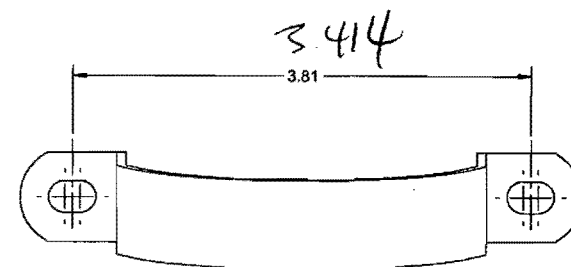
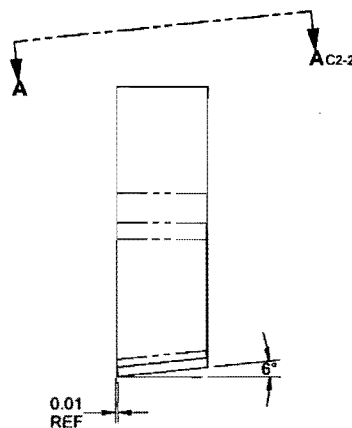
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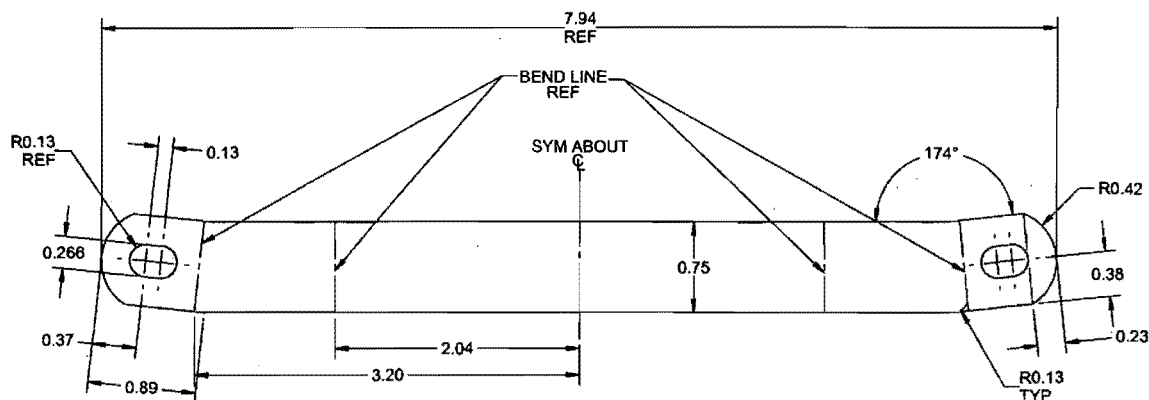
NOTE: Date & initial all entries



D4382-1 ANGLED BEARPAW CLAMP



VIEW A-A D3-2



**D4382-1F ANGLED BEARPAW CLAMP
(FLAT PATTERN)**

RELEASED
2011-04-23
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4382	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		ANGLED BEARPAW CLAMP	NTS
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